

Aero Design Ltd.**Work Order Control Sheet****Work Order#:** 2017-98 **Date Opened:** 12 June 2017 **Title:** Fabrication**Aircraft OEM:** Eurocopter **Aircraft Model:** AS350 **Product Type:** Bicycle Rack **Product Model:** Bushing **Quantity:** 35**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification
Time Sheet (R&D)
Notes

Initial or N/A

DM
N/A
DM
N/A
N/A
JC
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JC
N/A

Drawing List

Drawing #	Rev #	Description	Initial or N/A
100224	0	Bushing	DM

Traveller

Initial or N/A

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

35
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

N/A
DM
N/A
N/A
JC

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Notes:

Work performed by:

Print: D. MartynSign: SCA: AD05Date: 12-Jun-17

ICC / Dual Inspection performed by:

Print: N/ASign: SCA: Date:

Work Order closed by:

Print: J. ClarkeSign: SCA: AD02Date: 12-Jun-17

Approved Manufacturing Facility 73-04

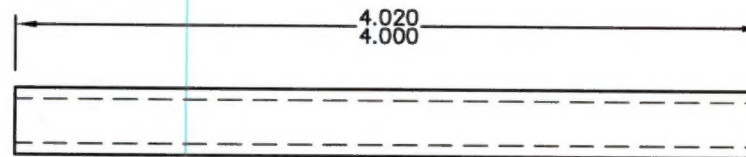
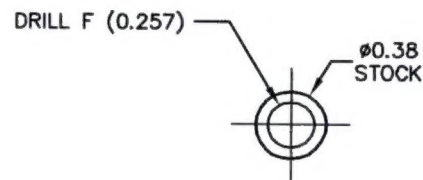
Form 20/0/03

Rev. Original 23 Sep 2014

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		


WO# 2017-98



NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.

① BUSHING

100224-01		01	BUSHING	304 STAINLESS STEEL	ASTM A269	Ø0.375 X 0.065 TUBE	
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE	
QTY	LIST OF MATERIALS						
		APPROVALS	DATE	<div><div>AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.483.2376 www.aerodesign.ca</div></div>			
		DRAWN: JEFF CLARKE	30 JUNE 2016				
		CHECKED: JASON REKVE	30 JUNE 2016				
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:		AIRBUS HELICOPTERS AS350/AS355/EC130 BICYCLE RACK INSTALLATION BUSHING FABRICATION			
		DECIMALS	ANGLES				
		X.XXX ±0.010 X.XX ±0.03 X.X ±0.1	±1/2°				
		SCALE 1 : 1		DWG. SIZE	DWG. NO.	REV.	
		SHEET 1 OF 1		A4	100224	0	

Aero Design Ltd.
Component Fabrication

Work Order Number: 2017-98

100224-01 Bushing

Date: June 12/2017

Notes:

Cutting speed 1030 RPM

Drilling speed to 320 RPM.

Maximum depth fo cut not to exceed .020" per pass

Rapid Tap cutting fluid or equivelant coolent required

Tasks	SCA
1. Record material PO below	88
2. Cut .375" x .065" wall 304 Stainless Steel tubing to 4.060" in length	88
3. Debur one end on buffing wheel	88
4. Set Lathe to 1030 RPM	AD-05
5. Using number letter F drill bore 2.5" deep and debur with hand held countersink	AD-05
6. Set .375 Collet stop to 3.5" deep	AD-05
7. Flip part inserting finished end of part into collet ensuring contact with the collet stop.	AD-05
8. Set lathe bed stop to finished part length IAW drawing 100224 Item 01	AD-05
9. Face end with a maximum depth of cut not to exceed .020" until contact with lathe bed stop is achieved	AD-05
10. Repeat steps 5 through 8	AD-05
11. Inspect finish and dimensions of final part.	AD-05
12. Tag completed parts IAW Aero Design MPM.	AD-05

AD
73-04
AD
73-04
020
73-04
02

Material Purchase Order Number PO 15073

Batch Quantity 35 June 12/2017